

Work Order ID 91216

October-03-12 2:38:12 PM

91216

Page 1

Item ID: D2661-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Stop ***NS2***

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12-10-03 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2661

Rev E

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Program part number and batch number.

Program part number and batch number
MACHINE AS PER DWG AND FOLIO FB073

FOLIO REV: AA
DWG REV: E

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

PO 12/11/19
FK 12/11/16

30 0

PO 12/11/19
FK 12/11/16

30 0

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Item ID: D2661-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

F.K 12/11/16
PD 12/11/19
12/19

30 0

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

30 0 DAS 25 12-11-20

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

30 X 0 M 12/11/20

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October-03-12 2:38:12 PM

Item ID: D2661-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Stop

NS2

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Memo

START TIME:

FINISH TIME:

0.00

OVEN TEMPERATURE:

Powder Coating

3200 F

10-10

10-40

30 X 0

mf 12/11/22

m 123383

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

30 0 12-11-22



170

Identify as per dwg & Stock Location: ST

0.00

170

Packaging

Memo

0.00

Packaging

432

12/11/22 (34)

Work Order ID 91216

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91216

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Item ID: D2661-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Saddle, LH Fwd Aft Out 206

Stop ***NS2***

Start Date: 03/10/2012 Start Qty: 30.00

30

Cust Item ID:

Required Date: 05/12/2012 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/11/23 *[Signature]*

MF
12-11-22

Picklist Print

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Page 1

Work Order ID: 91216

91216

Parent Item: D2661-1

D2661-1

Parent Item Name: Saddle, LH Fwd Aft Out 206

Start Date: 03/10/2012

Required Date: 05/12/2012

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP: C00.11.01Removed P/O for Powder Coat - in house
processEC IPP REV:D
REDESIGN PER ENG ERROR 11-11-17 JLM VERIFIED BY:DD
IPP Rev:D As per Rev D 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	24.0000	1	30			

D6101-003

**

Saddle Billet, 7075

Location	Loc Qty	Loc Code
MAT040	26	
73775	2	
73780	7	
78599	10	
80765	0	
MAT042	-3	
87498	4	
MAT044	1	
73769	1	
91238		

30

FK 12/11/15

DART AEROSPACE LTD		Work Order:	91216
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.126	.118	.120	.120	.118
H	0.210	0.230		.222	.225	.224	.224	.224
I	0.615	0.685		.680	.680	.680	.680	.680
J	2.470	2.510		2.490	2.491	2.491	2.491	2.491
K	1.313	1.343		1.322	1.325	1.326	1.326	1.325
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.1355	1.136	1.138	1.137	1.1355
O	0.100	0.180		.135	.135	.135	.135	.135
P	0.100	0.140	.133	.128	.128	.127	.128	.127
Q	0.240	0.260		.250	.253	.252	.252	.252
R	0.677	0.697		.687	.688	.687	.688	.689
S	0.100	0.140		.120	.120	.119	.120	.120
T	1.565	1.585		1.576	1.576	1.579	1.578	1.576
U	0.540	0.560		.550	.550	.550	.551	.550
V	0.912	0.932		.922	.922	.922	.920	.920
W	0.787	0.807		.797	.798	.798	.799	.799
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.497	.498	.497	.495
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.001	1.001	1.001	1.001	1.001
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.504	.504	.504	.504	.503
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.237	.237	.237	.237
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.112	.112	.112	.112
Accept/Reject				✓	✓	✓	✓	✓

Measured by: F. K.	Date: 12/11/15
Audited by: 25	Date: 12-11-20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD				Work Order: 91216	
Description: 206 Saddle, Outboard, Left side				Part Number: D2661-1	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				#6	#7	#8	#9	#10
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.498	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.118	.117	.117	.115	.115
H	0.210	0.230		.223	.220	.221	.221	.220
I	0.615	0.685		.675	.675	.675	.675	.675
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.325	1.325	1.325	1.325	1.325
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.135	1.135	1.130	1.134	1.133
O	0.100	0.180		.145	.145	.145	.145	.145
P	0.100	0.140		.126	.123	.125	.124	.124
Q	0.240	0.260		.249	.247	.250	.249	.249
R	0.677	0.697		.687	.686	.686	.685	.686
S	0.100	0.140		.114	.114	.117	.116	.115
T	1.565	1.585		1.576	1.575	1.570	1.574	1.574
U	0.540	0.560		.544	.545	.546	.548	.547
V	0.912	0.932		.917	.918	.919	.919	.917
W	0.787	0.807		.797	.797	.798	.797	.798
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.495	.497	.497	.497	.493
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.001	1.001	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.503	.505	.503	.503	.503
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.237	.235	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.112	.110	.111	.111	.111
Accept/Reject				✓	✓	✓	✓	✓

Measured by: PO DAG	Date: 12/11/17
Audited by: 25	Date: 12-11-20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD		Work Order:	91216
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK:		Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.115	.117	.117	.116	.117
H	0.210	0.230		.220	.220	.220	.220	.221
I	0.615	0.685		.675	.675	.675	.675	.675
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.325	1.325	1.325	1.325	1.325
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.136	1.135	1.135	1.133	1.134
O	0.100	0.180		.145	.145	.145	.145	.145
P	0.100	0.140		.125	.125	.125	.125	.125
Q	0.240	0.260		.249	.249	.249	.249	.249
R	0.677	0.697		.686	.687	.686	.686	.687
S	0.100	0.140		.117	.116	.116	.115	.116
T	1.565	1.585		1.576	1.573	1.575	1.574	1.574
U	0.540	0.560		.551	.545	.545	.547	.547
V	0.912	0.932		.919	.917	.916	.917	.919
W	0.787	0.807		.798	.798	.797	.799	.799
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.499	.499	.497	.500	.500
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.503	.504	.502	.502	.503
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.511	.511	.511	.512	.512
AH	0.100	0.120		.111	.111	.111	.111	.111
Accept/Reject								

Measured by: PD	Date: 12/11/18
Audited by: 25	Date: 12-11-18
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD				Work Order: 91216	
Description: 206 Saddle, Outboard, Left side				Part Number: D2661-1	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				16	2 ₁₇	3 ₁₈	4 ₁₉	5 ₂₀
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.372	1.372	1.372	1.372
G	0.100	0.140		.116	.117	.117	.117	.118
H	0.210	0.230		.220	.220	.226	.220	.221
I	0.615	0.685		.675	.675	.675	.675	.675
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.325	1.325	1.330	1.325	1.325
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.130	1.134	1.135	1.136	1.136
O	0.100	0.180		.145	.145	.145	.145	.145
P	0.100	0.140		.126	.126	.126	.125	.125
Q	0.240	0.260		.249	.250	.254	.249	.249
R	0.677	0.697		.686	.685	.685	.685	.686
S	0.100	0.140		.118	.118	.117	.118	.115
T	1.565	1.585		1.571	1.574	1.575	1.577	1.577
U	0.540	0.560		.546	.547	.548	.547	.546
V	0.912	0.932		.917	.919	.917	.918	.920
W	0.787	0.807		.798	.797	.798	.797	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.500	.501	.502	.500
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.503	.503	.502	.503	.502
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.235	.236	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.110	.111	.111	.111	.111
Accept/Reject								

Measured by: [Signature]	Date: 12/11/18
Audited by: [Signature]	Date: 12-11-20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	[Signature]

DART AEROSPACE LTD				Work Order: 91216	
Description: 206 Saddle, Outboard, Left side				Part Number: D2661-1	
Inspection Dwg: D2661 Rev: E DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				21	22	23	24	25
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.117	.116	.117	.117	.117
H	0.210	0.230		.220	.222	.220	.222	.220
I	0.615	0.685		.675	.675	.675	.675	.675
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.325	1.325	1.325	1.325	1.325
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.136	1.135	1.135	1.135	1.131
O	0.100	0.180		.145	.145	.145	.145	.145
P	0.100	0.140		.125	.126	.125	.124	.127
Q	0.240	0.260		.249	.249	.249	.249	.251
R	0.677	0.697		.688	.687	.685	.685	.685
S	0.100	0.140		.118	.118	.117	.117	.118
T	1.565	1.585		1.576	1.575	1.575	1.576	1.572
U	0.540	0.560		.547	.549	.547	.547	.546
V	0.912	0.932		.917	.919	.919	.919	.917
W	0.787	0.807		.798	.798	.798	.798	.799
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.501	.501	.500	.499
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.503	.502	.502	.502	.503
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.511	.512
AH	0.100	0.120		.111	.111	.111	.111	.111
Accept/Reject				✓	✓	✓	✓	✓

Measured by: PD	Date: 12/11/19
Audited by: 25	Date: 12-11-20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ	

DART AEROSPACE LTD		Work Order:	91216
Description: 206 Saddle, Outboard, Left side		Part Number:	D2661-1
Inspection Dwg: D2661 Rev: E DSK: Rev:		Page 1 of 1	

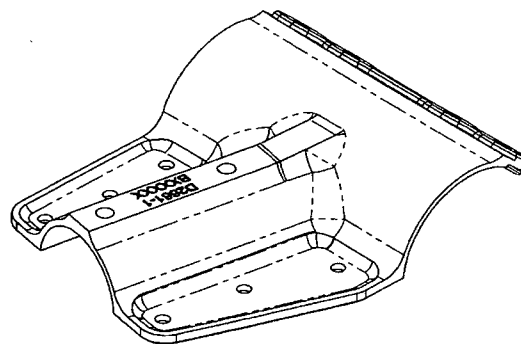
FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				#26	#27	#28	#29	#30
A	3.611	3.621		3.616	3.616	3.616	3.616	3.616
B	0.256	0.263		.258	.258	.258	.258	.258
C	0.315	0.322		.316	.316	.316	.316	.316
D	2.495	2.505		2.500	2.500	2.500	2.500	2.500
E	1.674	1.684		1.679	1.679	1.679	1.679	1.679
F	1.357	1.367		1.362	1.362	1.362	1.362	1.362
G	0.100	0.140		.115	.121	.117	.116	.116
H	0.210	0.230		.220	.219	.222	.221	.221
I	0.615	0.685		.675	.675	.675	.675	.675
J	2.470	2.510		2.490	2.490	2.490	2.490	2.490
K	1.313	1.343		1.325	1.325	1.325	1.325	1.325
L	0.178	0.198		.188	.188	.188	.188	.188
M	0.470	0.530		.500	.500	.500	.500	.500
N	1.125	1.145		1.133	1.138	1.136	1.134	1.133
O	0.100	0.180		.145	.145	.145	.145	.145
P	0.100	0.140		.126	.125	.126	.126	.126
Q	0.240	0.260		.249	.247	.249	.249	.249
R	0.677	0.697		.688	.685	.685	.688	.686
S	0.100	0.140		.117	.114	.115	.115	.117
T	1.565	1.585		1.573	1.579	1.576	1.575	1.574
U	0.540	0.560		.545	.546	.546	.546	.547
V	0.912	0.932		.920	.917	.917	.919	.917
W	0.787	0.807		.797	.797	.798	.798	.797
X	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Y	4.995	5.005		5.000	5.000	5.000	5.000	5.000
Z	0.490	0.510		.500	.499	.499	.500	.499
AA	0.312	0.319		.314	.314	.314	.314	.314
AB	0.990	1.010		1.000	1.000	1.000	1.000	1.000
AC	1.245	1.255		1.250	1.250	1.250	1.250	1.250
AD	0.490	0.510		.503	.501	.503	.504	.504
AE	3.745	3.755		3.750	3.750	3.750	3.750	3.750
AF	0.235	0.240		.236	.236	.236	.236	.236
AG	0.510	0.515		.512	.512	.512	.512	.512
AH	0.100	0.120		.111	.111	.111	.111	.111
Accept/Reject				✓	✓	✓	✓	✓

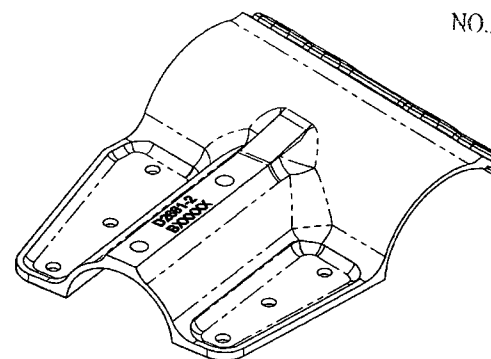
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Audited by: [Signature]	Date: 12-11-20
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	11.11.07	Dimensions C and F revised	KJ	
H	12.01.10	Revised per drawing revision E	KJ [Signature]	[Signature]

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 WORK ORDER
 NO. 91216 MJS
 12-10-03



D2661-1 SADDLE, OUTSIDE, LH

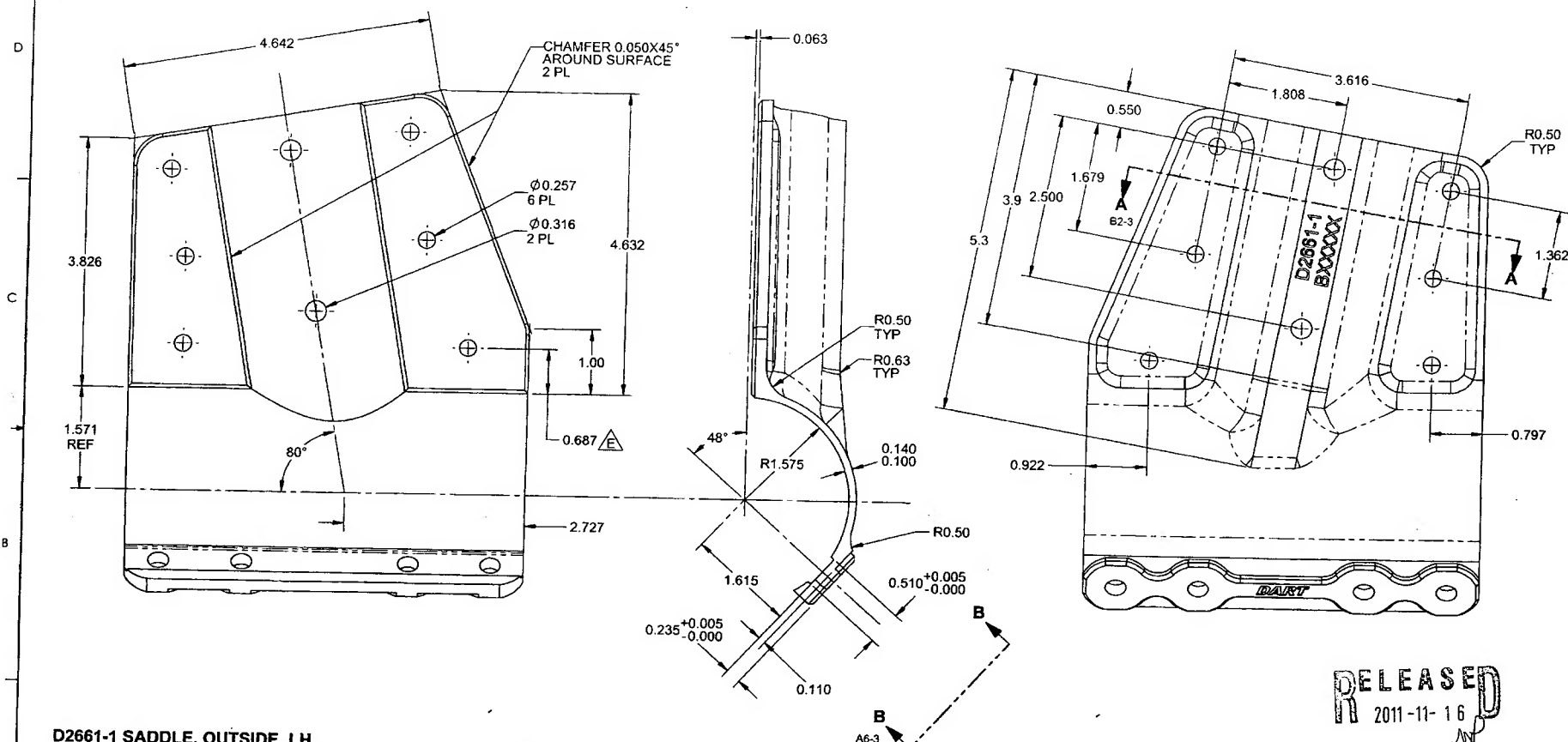


D2661-2 SADDLE, OUTSIDE, RH

RELEASED
 2011-11-16

E	REDRAW & REFORMAT DWG; 0.687 WAS 0.547 (B6-2, B8-4), REF NCR 11-935	CP	11.10.31
D	R0.188 WAS R0.30; Ø0.316 WAS Ø0.313	CB	06.11.08
C	INCORPORATE DEO 9122, 9102, 9095	CB	06.05.29
B	ANGLE AND NOTES ADDED	KE	97.07.11
A	NEW ISSUE	DS	07.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.31		

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D2661	REV. E SHEET 1 OF 5
TITLE SADDLE, OUTSIDE	SCALE NTS
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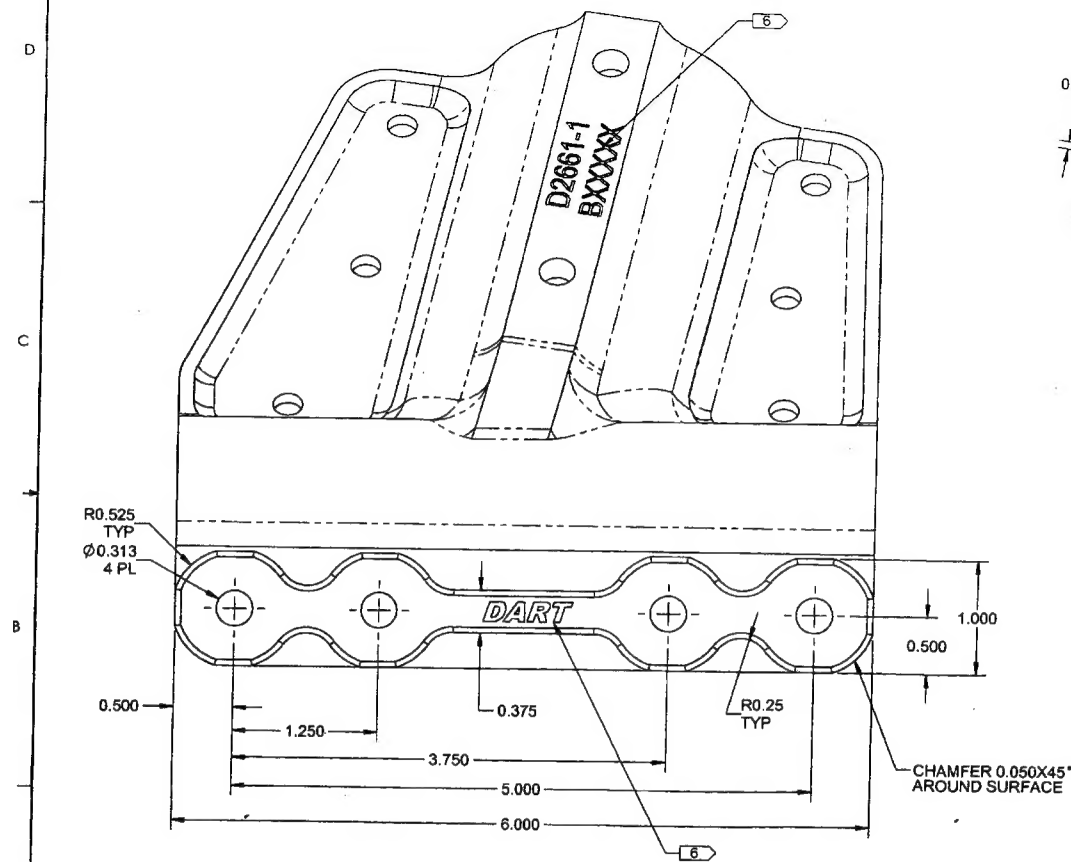


- SADDLE, OUTSIDE, LH**
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
 - 7) WEIGHT: 0.79 lbs

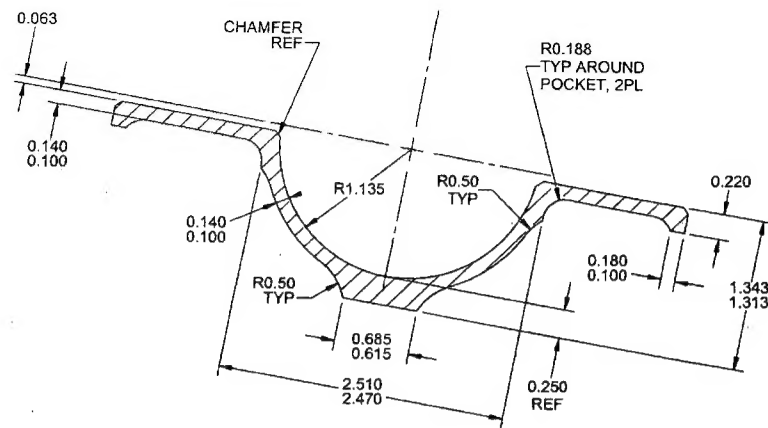
RELEASE
2011-11-16

DESIGN	<i>g</i>	DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D2661 TITLE SADDLE, OUTSIDE COPYRIGHT © 1987 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	REV.
DRAWN	<i>g</i>		SHEET 2 OF
CHECKED	<i>ASS</i>		SCAL
MFG. APPR.	<i>[Signature]</i>		NT.
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.10.31		

91216



VIEW B-B
SCALE 1.5X
VIEW ROTATED

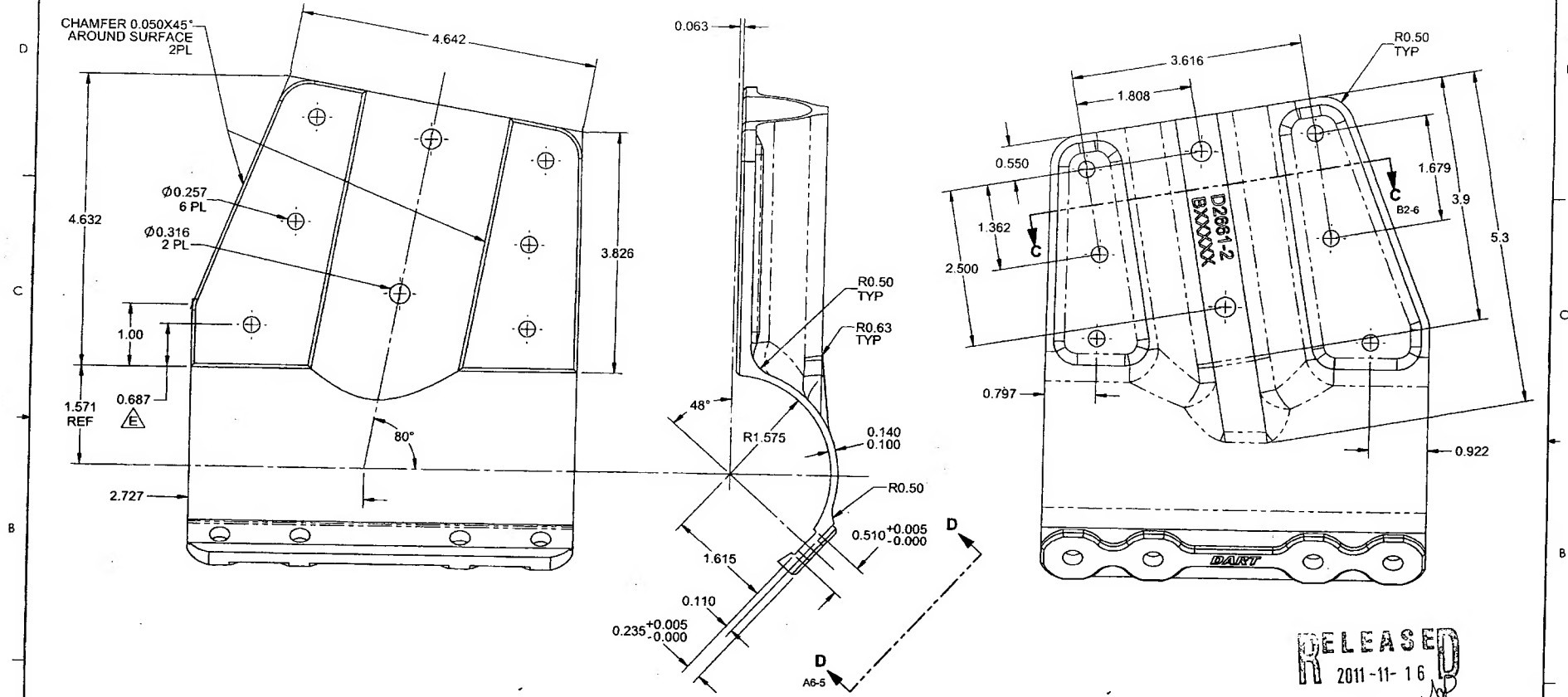


VIEW A-A
SCALE 1.5X

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2011-11-16

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2661	REV. E
MFG. APPR.			SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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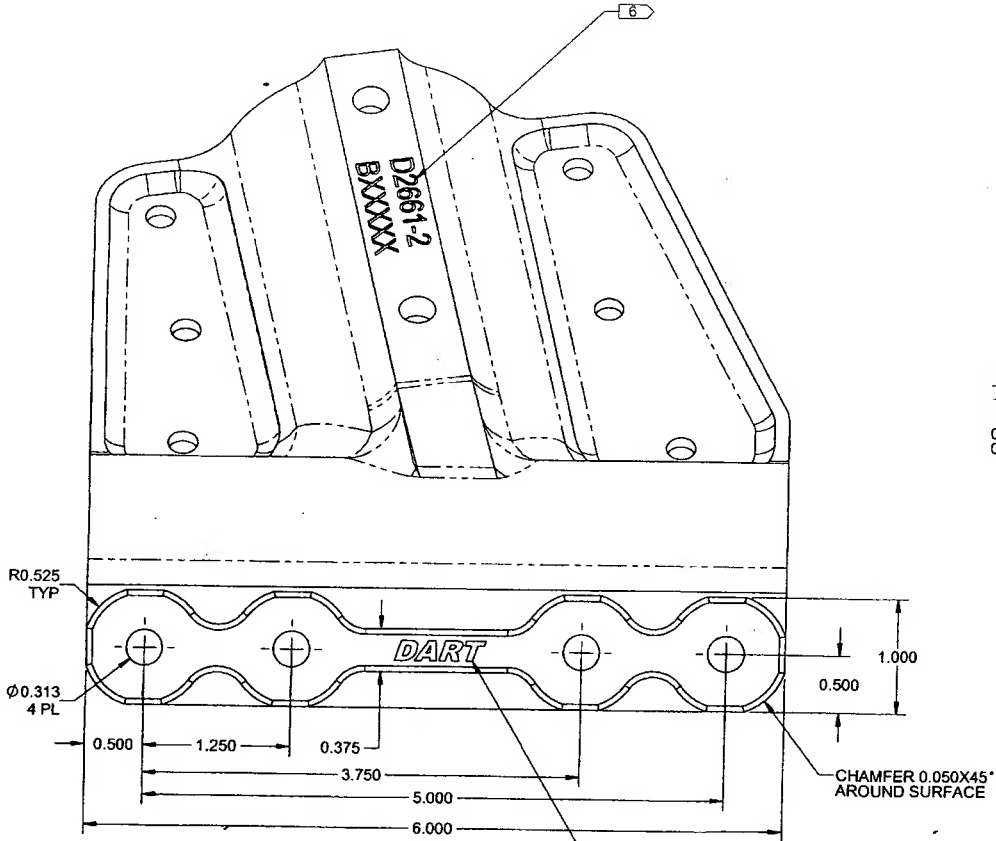


D2661-2 SADDLE, OUTSIDE, RH

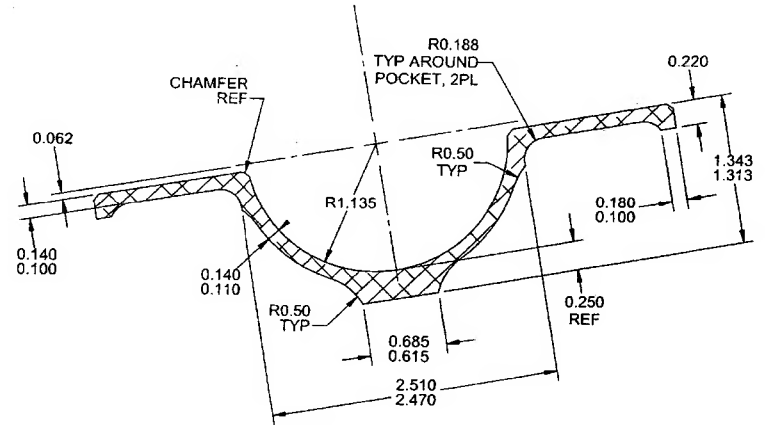
- 1) MATERIAL: 7075-T7351 ALUMINUM PLATE PER QQ-A-250/12, AMS-QQ-A-250/12, OR ASTM B209
MAKE FROM D6101-003 SADDLE BILLET
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.010 WITH MIN RADIUS OF 0.010
IDENTIFY WITH DART LOGO PER DART QSI 044 6.3 (CNC ENGRAVING)
USING MAX DEPTH OF 0.015 WITH MIN RADIUS OF 0.25
- 7) WEIGHT: 0.79 lbs

DESIGN		DART AEROSPACE USA, INC.	
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CHECKED	ASS	DRAWING NO.	REV. E
MFG. APPR.		D2661	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SADDLE, OUTSIDE	NTS
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91216



VIEW D-D B4-4
SCALE 1.5X
VIEW ROTATED



SECTION C-C C1-4
SCALE 1.5X

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2011-11-16

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MFG. APPR.		D2661	SHEET 5 OF 5
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